

Date: Tuesday, 4/4/2006 1:27:08 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER TIE DOWN ASS'Y (LOCKING)
Job Number	: 26489		
Estimate Number	: 10495		
P.O. Number	: N/A	Part Number	: D2360
This Issue	: 4/4/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2360 / D2341
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26443	Drawing Revision	: C1 / E
		Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 4/24/2006
Checked & Approved By	: <u>06.04.04</u>	Qty:	4 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6201	T Extrusion 4X4X3/8
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Comment: Qty.: 1.1067 f(s)/Unit Total: 4.4268 f(s)
 Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion)
 Batch: 526538

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 12.65" Long

SD 06.05.06 4

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio D2341 and Dwg D2341

SD 06.05.07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 06.05.07

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SD 06.05.08 4

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Deburr and Tumble



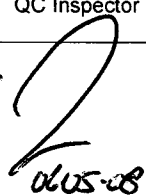
SD 06.05.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.05.07	6	During assembly 2 parts stuck together and caused damage on the edge of on part 020" deep in 2 locations. See photo's.		Fill damaged areas with weld, and grind flush to dwg dimensions. AS per QS1 004.	SD 06.03.08 f.e. 06.05.8	 060508	8 May 06	 060508

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26489

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



06-05-08 (4)

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06/05/09 (4)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M 06-05-16 (4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Knob

Batch B16177B

12.0

D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Lock Channel

B26457

13.0

D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Inventory

B19288

14.0

D2367

Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Inventory

B26597

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:27:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26489

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Quick Release

B26497(8) ~~B26507(1)~~

16.0

D2373

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spring

B19508(3) B26458(1)

17.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pip Pin Assembly

B25824

18.0

AN526C1032R18

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

M14523

19.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

M18235 M100743

20.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
Washer

M18235

21.0

MS20470AD34

Rivet,Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Rivet,Universal Head

M15541

22.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut

M18917

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:27:09 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26489

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

M13719

24.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw

M15432

25.0

NAS679A3W

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut

M1463

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D2360

SAD 06:05:18

(4)

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-18 (4)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 50 171

06/05/19 (4)

29.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



06-05-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>BW</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>D108</i>	DRAWING NO. D2360	REV. C SHEET 1 OF 2
DATE 97.08.27		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING)	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
<i>C1</i>	<i>02.09.24</i>	<i>D2002-015 WAS D2376</i>	

RELEASED
97 08 27 BW

D2360	Part No.	Description
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELTRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2376	KNOB (DELTRIN) <i>D2002-015</i>
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
<i>2</i>	AN960JD10	WASHER
<i>5</i>	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

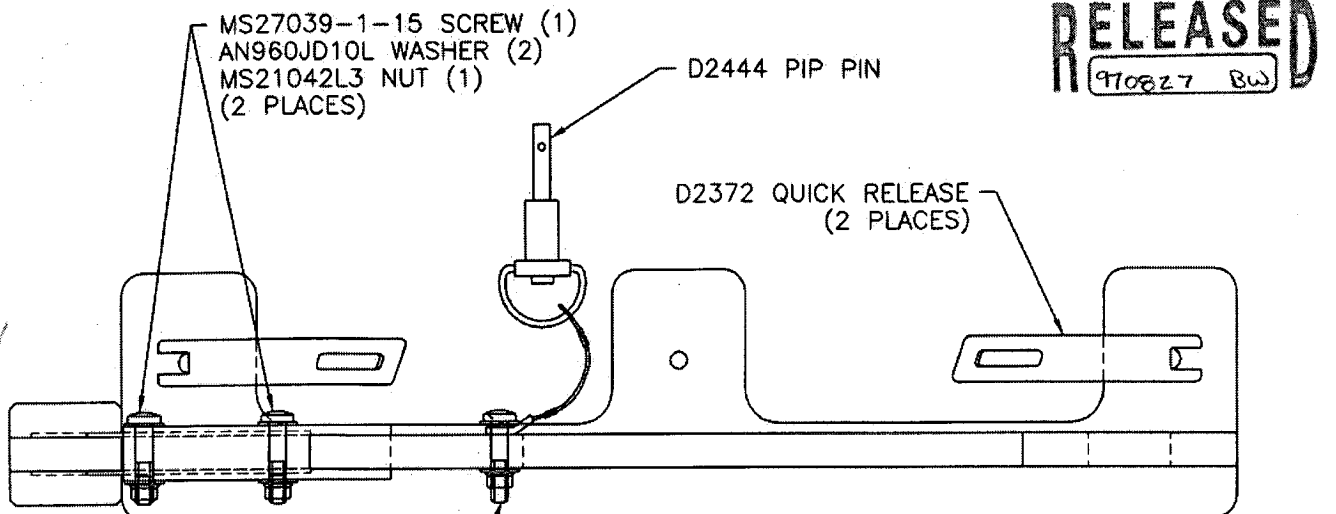
KE 99.03.02

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WITHOUT NOTICE
WORK ORDER
NO. *26489*



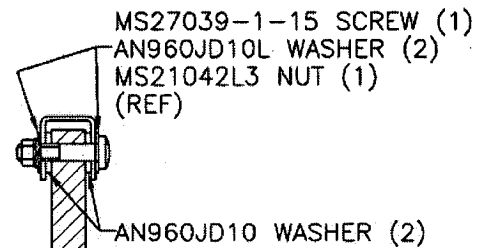
DESIGN <i>BW</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>LE</i>	APPROVED <i>MB</i>	DRAWING NO. D2360	REV. C SHEET 2 OF 2
DATE 97.08.27		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING)	

RELEASED
970827 BW

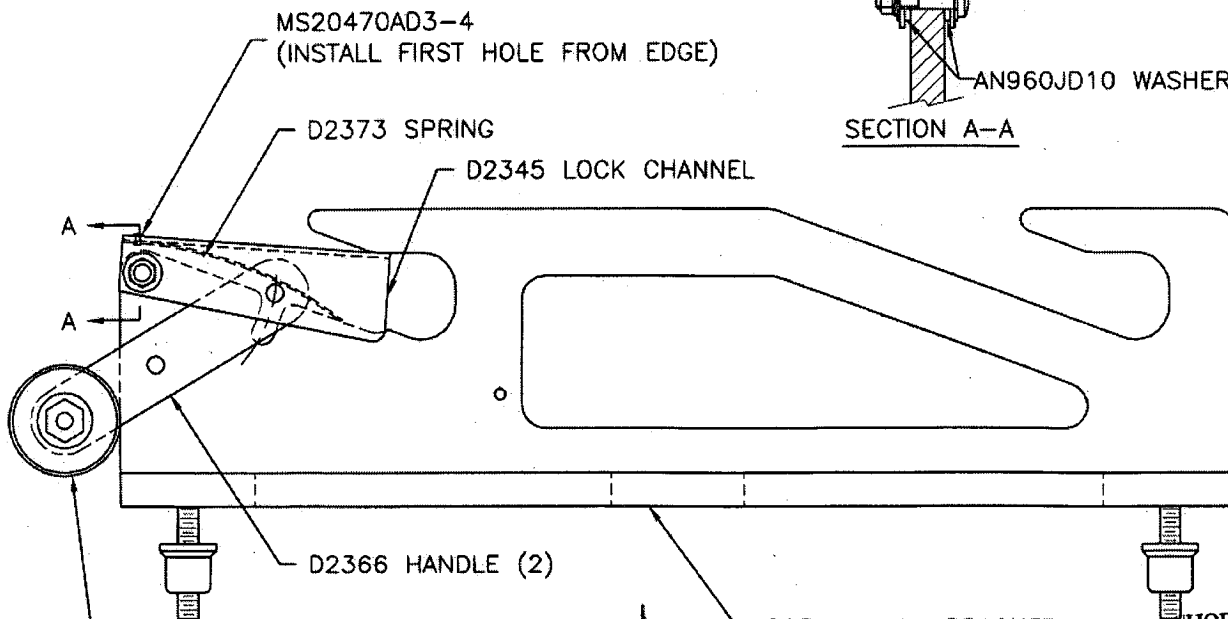


MS27039-1-13 SCREW
AN960JD10LWASH (3)
MS21042L3 NUT

REF 99.07.02



SECTION A-A



~~D2376 KNOB (2)~~ *D2002-015 KNOB (2)*
D2367 KNOB (1)
AN526C1032R18 SCREW (1)
AN960JD10L WASHER (1)
NAS679A3W NUT (1)

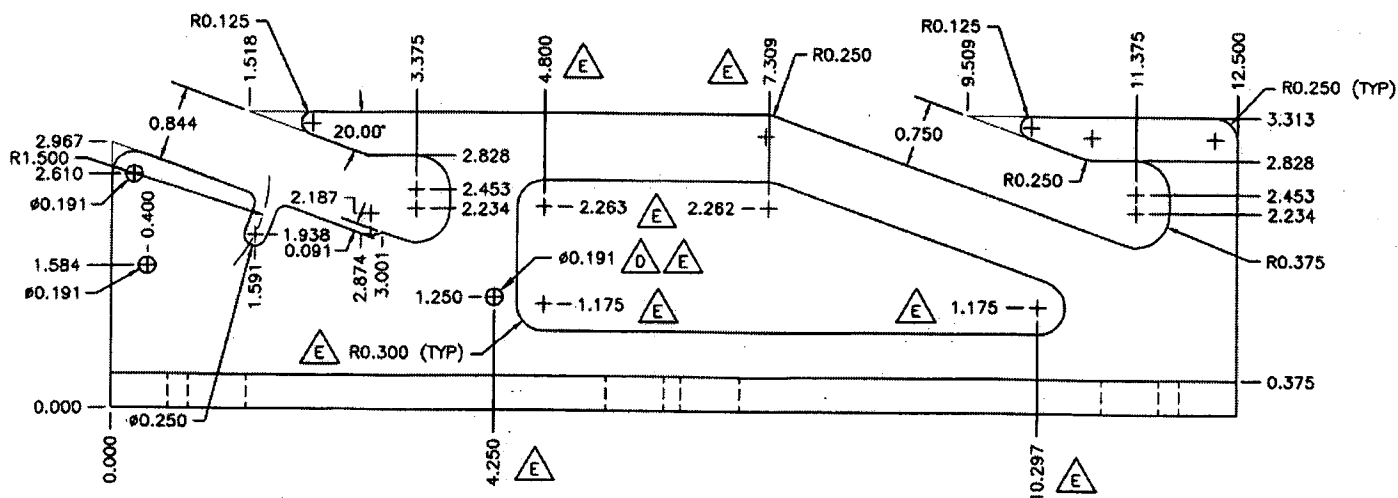
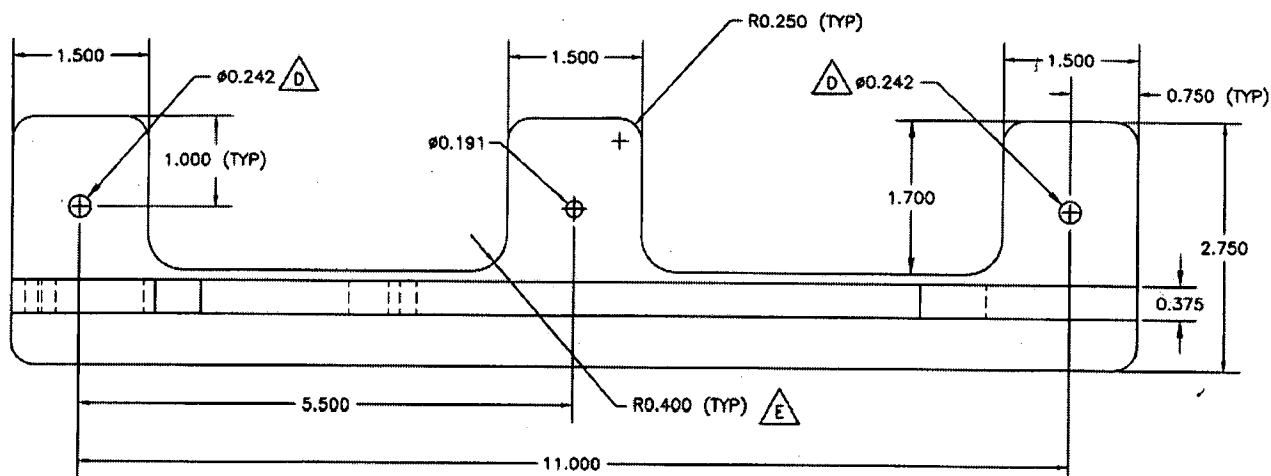
D2341 LOCK BRACKET

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DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED mm	APPROVED BW	DRAWING NO. D2341	REV. E SHEET 1 OF 1
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02:14	MODIFIED LOCK	
D	95.02:20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	

RELEASED
971003 KE
TSR A130



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION
FINISH: ANODIZE

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SUBJECT TO AMENDMENT

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WITHOUT NOTICE
WORK ORDER
NO. 26489

Work Order:	26489
Part Number:	D 2391-1
Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article
 ☐ Prototype

Part Number	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500		1.502	/			
1.000		1.005	/			
Ø.242		Ø.242	/			
Ø.191		Ø.191	/			
R.250		R.250	/			
1.700		1.698	/			
.750		.754	/			
2.750		2.756	/			
11.000		10.996	/			
5.500		5.501	/			
1.584		1.586	/			
Ø.191		Ø.191	/			
2.610		2.612	/			
.844		.842	/			
1.250		1.2495	/			
.750		.752	/			
12.500		12.502	/			
3.313		3.314	/			
4.250		4.250	/			
.400		.400	/			

Audited by: <u>S.G.</u> Date: <u>06/05/08</u>	Prototype Approval: <u>N/A</u> Date: <u>N/A</u>
Design: <u>SN</u> Date Issued: <u>06.05.07</u>	Revised by: <u>KJ/RF</u> Approved: <u>[Signature]</u>

